

52

SPUT

DART AEROSPACE LTD	Work Order:	21950 A
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2	Qty:	4 60 (4)
RF 03-02-17 RF 03-02-28		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.09 (Minimum lots of 30)	EP	04.11.23	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M1658d Identify as D3065-1 4.320" RF 02.11.29 4.320"	EP	05/01/14	60
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") 4.250" RF Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M16589 Identify as D3065-3	EP	05/01/14	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M16584 Identify as D3065-7	EP	05/01/14	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M16241 Identify as D3065-5 (Note: make 2 legs per assembly) M16203	EP	05/01/14	60
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M16241 Identify as D3066-1 M16203 (Note: make 2 spacers per assembly) M15021	EP	05/01/14	60
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	EP	05/01/17	60
8	MV	Deburr to take measurement	EP	05/01/17	60
9	QC2	Inspect parts as they come off the CNC machine	EP	05/01/17	60
10	QC8	Second check	EP	05/01/17	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	EP	05/01/17	60
12	MV	Deburr to take measurement	EP	05/01/17	60
13	QC2	Inspect parts as they come off the CNC machine	EP	05/01/17	60
14	QC8	Second check	EP	05/01/17	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	SD	05.01.17	60
16	MV	Deburr to take measurement	SD	05.01.17	60
17	QC2	Inspect parts as they come off the CNC machine	SD	05.01.17	60
18	QC8	Second check	EP	05/01/17	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	EP	05/01/17	120

RELEASED


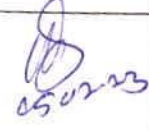

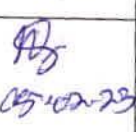
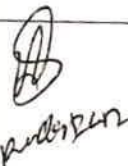
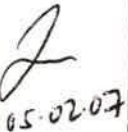
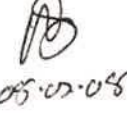

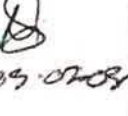
DART AEROSPACE LTD		Work Order:	21950
Description: HI - Step Leg Assembly		Part Number:	D3065-041
RF 03.02.28		Qty:	60 (4)
Dwg: D3065 Rev. A2		Page 2 of 2	
RF 03.02.17			

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	EP	05/01/17	120																								
20	MV	Deburr to take measurement	EP	05/01/17	120																								
21	QC2	Inspect parts as they come off the CNC machine	EP	05/01/17	120																								
22	QC8	Second check	EP	05/01/17	120																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	EP	05/01/17	60																								
24	MV	Deburr to take measurement	EP	05/01/17	60																								
25	QC2	Inspect parts as they come off the CNC machine	EP	05/01/17	60																								
26	QC8	Second check	EP	05/01/17	60																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack. (59)	EP	05-02-04	60 / 59 PT.																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 59 59	EP	05.02.09	59																								
29	QC5	Inspect work to Step 28	EP	05/02/09	59																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	PD	05-02-22	59																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B21950</td></tr><tr><td>1</td><td>D3065-3</td><td>Spacer</td><td>B21950</td></tr><tr><td>2</td><td>D3065-5</td><td>Leg</td><td>B21950</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B21950</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet</td><td>M15072</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B21950	1	D3065-3	Spacer	B21950	2	D3065-5	Leg	B21950	1	D3065-7	Spacer	B21950	30	MS20470AD4-4	Rivet	M15072	PD	05-02-22	4
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B21950																										
1	D3065-3	Spacer	B21950																										
2	D3065-5	Leg	B21950																										
1	D3065-7	Spacer	B21950																										
30	MS20470AD4-4	Rivet	M15072																										
32	QC5	Inspect work to Step 31	PD	05/02/22	4																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	PD	05-02-22	4																								
34	AC	Cost / part 29.53	545	05.02.23	4																								
35	DC	Close W/O 35.85 Inspect Level 21	EP	05.02.23	4																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 21950		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-02-03	27	Found 1x D 3065-3 spacer With a splash in the hole	 RICK PETER	Scrap it - No replace	ml 05-02-02	 05-02-03	 RICK PETER	 05-02-23
05-02-08	28	1x D 3065-1 center hole punched crooked causing A hole crack.	 RICK PETER	Destroy	 05-02-07	 05-02-08	 RICK PETER	 05-02-08

Part No: D3065-041

PAR #: _____

Fault Category: Manuf/MiscNCR: ☒ Yes ☐ NoDQA: Date: 05/02/04

NOTE: Date & initial all entries

QA: N/C Closed: Date: 05.02.28